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U/R

APR 1, 2019

C10-C

Job Sheet 198695



Part No: C10-C

Job Qty: 1 pcs

Part Name: Single Cage



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 8/1/19

Job Tracking No:

Created By: Jennifer Renwick

Due Date: 8/12/19

Description:

Type: SOLD *stock*

Note: URF 19-658 DWG C10-C REV 2 IPP Rev. A 19.03.18 New issue DP Verify DD

Ship Via: *OKAY TO SHIP*

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	External Load - 1	1 pcs	8/12/19	8/12/19	0.00	1.00	External Load - 1		<i>AP 2019/09/20</i>
							External Load - 2		
							External Load - 3		
120	QC 5	1 pcs	8/12/19	8/12/19	0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
							QC 5 - 61		
							QC 5 - 81		
140	Packaging 3-1 - Stock - B4B	1 pcs	8/12/19	8/12/19	0.00	0.00	Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		
							Packaging 3 - 6 - B4B		
							Packaging 3 - 7 - B4B		
							Packaging 3 - 8 - B4B		
							Packaging 3 - 9 - B4B		

*DAS
30
9-89*

SEP 20 2019

*DAS
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9-89*

SEP 20 2019

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				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
160 QC 21 - SA	1 pcs	8/12/19	0.00 0.00	QC 21 - SA - 21	
<i>closed up only</i>				QC 21 - SA - 70	SEP 23 2019
				QC 21 - SA - 53	DAS 70

Part Op 100 - ASSEMBLE AS PER DWG ***HAND TIGHTEN ALL BOLTS, SPREAD COTTER PIN JUST ENOUGH SO THAT IT
 Descriptions: WILL NOT FALL OUT***

120 - (QC5- Inspect part completeness to step on W/O)

140 - (Identify as per dwg & Stock Location: *SA*) TAD

160 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
90576A118	Cage Bumper Nut	1 pcs (1 ea)	100-External Load - 1	5142212
AN12H40	Bolt	1 pcs (1 ea)	100-External Load - 1	5099982
AN310-12	Castellated Nut	1 pcs (1 ea)	100-External Load - 1	5004855
AN8-37A	1/2-20 X 3.969" Bolt	2 Ea (2 ea)	100-External Load - 1	5127355
C10-27	Cage Weldment	1 pcs (1 ea)	100-External Load - 1	5203199
C10-28AP	Lifting Bushing (No Swivel)	1 Ea (1 ea)	100-External Load - 1	5005649
C10-34	Bumper	1 pcs (1 ea)	100-External Load - 1	5209915
MS21044N8	Nut, Self-Lock .500-20, UNJF-3B	2 Ea (2 ea)	100-External Load - 1	5200381
MS24665-363	Cotter Pin	1 Ea (1 ea)	100-External Load - 1	5092509
NAS1149C0663R	Washer (AN960C616)	1 Ea (1 ea)	100-External Load - 1	5076016-1
NAS1149F0832P	Washer (AN960-816L)	4 Ea (4 ea)	100-External Load - 1	5076018
NAS1149F1232P	Washer (AN960-1216L)	2 Ea (2 ea)	100-External Load - 1	5068664

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-External Load - 1	90576A118	1	48	0
	AN12H40	1	13	0
	AN310-12	1	18	0
	AN8-37A	2	28	0
	C10-27	1	0	0
	C10-28AP	1	48	0
	C10-34	1	6	0
	MS21044N8	2	50	0
	MS24665-363	1	72	0
	NAS1149C0663R	1	465	0
	NAS1149F0832P	4	191	0
	NAS1149F1232P	2	80	0
Part Specifications				
Specifications could not be found.				

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DQA: _____ Date: _____
QA Closed: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

Work Order update only

Work Order: <u>198695</u>		DISPOSITION		AGAINST DEPARTMENT/PROCESS			
Part No. <u>C10-C</u>		Rework ☐	Scrap ☐	Skid-tube Machining ☐	Cross tube Small Fab ☐	Water Jet Prod. Eng. Coord. ☐	Engineering Quality ☐
NCR No. _____		Use-as-is ☐	Suspected Unapproved ☐	Thermoforming Large Fab ☐	Finishing Composite ☐	Rec/Store/Packaging Supplier ☐	Other ☐
Date: <u>2019/09/20</u>	Step #: _____	QTY Effective: _____		MRB (QS1042) Approval <u>MLee</u> May 18, 2018			
Description Work Order Deviation		Disposition					
- C10-31 has been replaced with AN12H40 - C10-32 has been replaced with AN310-12 - C10-33 has been replaced with NAS1149F1232P - C10-35 has been called out using McMaster Carr P/N 90576A118 - C10-36 has been replaced with NAS1149C0663R - C10-37 has been replaced with MS24665-363		- This deviation is acceptable. - The AN12 bolt is sufficiency strong for its intended application - No impact on fit, form or function. - The MS24665-363 Cotter Pin must be changed in conjunction with the AN12H40 Bolt. - All fasteners must be in safety (1-3 threads exposed) use additional washers if necessary					
Completed By <u>A PARY</u>		Lead hand / Supervisor Approval Verification					
QC / QA Coordinator Approval							
Root Cause		FAULT CATEGORY					
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐		
Design ☒	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐		
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐		
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐		
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐		
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐		
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐		
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐		
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐		
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐		
Past Expiry Date ☐	Manufacturing Process ☐						
Misidentified ☐	Past Due ☐						
OTHER: _____							

Under Review Notification

Raised By: Ketan Tailor

Date: March 27, 2019

Product #: C10-C

Product Name: C10 CAGE

[illegible]

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